Thursday, August 29, 2013 3:28:51 PM

\*106428\*

Page 1

Item ID: D4148-041 Accept \*N900040100\* **Revision ID:** Item Name: FWD X-TUBE LUG ASS'Y **Start Date:** Start Qty: 4.00 \*4\* 8/29/2013 Required Date: 8/30/2013 Req'd Qty: 4.00 ECN 13-624 Reference: Date: \3 ·08° Fooling: MF Process Plan: Approvals: QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Work Center ID Description **Run Hours** Draw Nbr **Revision Nbr** D4148 E 140 0.00 \*140\* Mill Conv 0.00 Memo Conventional Milling Machine PULL FROM STOCK D4148-041 X 4 2 X B99763 1 X B100462 1 X B100998 AND REWORK TO NEW DRAWING DAS 150 QC5- Inspect part completeness to step on W/O 0.00 27 \*150\* 9-89 QC Memo Quality Control

Cust Item ID: **Customer:** Run Start Date:

Date:

Setup Start

Stop

Tool ID Tool # Plan Accept Reject Reject Insp. Code Qty Qty Number Stamp

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DQA:	dush	Date	13/10	103				_			*	DART'
QA Closed:	010	Date	13/	9/2	5 WORK ORDER NON	-CO	NFO	RMANCE / UPDA		ork Order up	odate only	AEROSPACE
Work Ord	or: le		1	1	DISPOSITION			A	······································	PARTMENT,		
Part I	Work Order: 106428  Part No. D4148-041  NCR No. 13-3069				Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Composite			1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Dat	e Step	Qty	Desc	ription of work order update or non-conformance	ł	nitial ief Eng	Action Descriptio		Sign & Date	Verification	QC Inspector
Design Doc/Data				Ho	Le \$0,266 position OFF by 0,020		^			P	DAS 27 9-89	QC IIISPECTOI
Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier	13/07	193 140	1		C - pid not us zero origina on axis	13	/9/3	Acceptable.  Adjustable of  Lill still in  OK.	levis nstell	13/4/3	1394	DAS 16 9-89 ি}/৫१/১৭
Training Transport Unapproved				X	Aris	EAL	II T CAT	TEGORY				
Landi	ing Gear				General	170	JET CA	ILGORI				
	Bendi Centro Cracks Crimp Cuffs Crush Heat	Not Conce /Kink/Rippl	e/Wave n Tube		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Unquali ions Incomplete/Unclea gned/off center eled	ar	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	$\vdash$	/Twist in Tu			Fit/Function	$\vdash$		Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

## \*106428\*

Work Order ID 106428

Thursday, August 29, 2013 3:28:51 PM

Item ID:

D4148-041

Revision ID: Item Name:

FWD X-TUBE LUG ASS'Y

**Start Date:** 

8/29/2013

Start Qty: 4.00

Req'd Qty: 4.00

\*4\*

**Cust Item ID:** 

**Customer:** 

Reference:

ECN 13-624

QC:

Approvals:

**Required Date: 8/30/2013** 

**Process Plan:** 

Date: Date:

**Tooling:** 

Accept

SPC (Y/N):

Date:

\*N900040100\*

Date:

Run

Setup Start

Stop

Sequence ID/ Work Center ID

160

\*160\*

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Number

Insp. Stamp

Packaging

Memo

QC21- Final Inspection - Work Order Release

0.00

\*170\*

170

QC Quality Control

Memo

0.00

DQA:	<del></del>	Date:			- WORK ORDER NON CONFORMANCE (URDATE								
QA Closed:		Date:		WORK ORDER NO	WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only  Work Order update only								
Work Order:				DISPOSITION			<u> </u>						
Work Order.				– Rework		Skid-tube Crosstu			]	Water Jet	Engineering		
Part N	lo.			Scrap	-		Machining	Crosstube Small Fab	Pro	d. Eng. Coor.	Quality		
			,	Use-as-is	$\vdash$		noforming	Finishing	4	re/Packaging	Other		
NCR N	lo			Suspected Unapproved			· —	Composite	]	Supplier			
Root		7	T T-	Description of work and an and	-4	In it in I	0.00		C: 0				
Cause	Date	Step	Qty L	Description of work order upda or non-conformance		Initial	Actio		Sign &	\/a=!£!==#!==	OC Increases		
Design	Date	step	Qty	or non-comormance		nief Eng	Descrip	Juon	Date	Verification	QC Inspector		
Doc/Data	$\dashv$												
Equip/Tooling	_	1											
Handling/Pre		1.						*					
Material									•				
Operator							•						
Offset/Setup		1											
Process													
Supplier													
Training													
Transport		1											
Unapproved											,		
					FA	ULT CA	TEGORY	-					
Landir	ng Gear			General		_			_		_		
ļ	Bending			Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced		
		ot Concer	ntric	BOM/Route		Grain			Over/Under	tolerance	Set-up		
	Cracks			Broken/Damage/Defect	<u> </u>	Hardwa	are		Part Incorred	ct	Temperature/Cure		
	Crimp/Ki	nk/Ripple	/Wave	Burrs		Inspect	ion Incomplete/Unq	jualified	Part Lost/Mi	ssing	Weld		
	Cuffs			Contamination		Instruct	tions Incomplete/Un	nclear	Part Moved		Wrong Stock Pulled		
	Crushing			Countersink			gned/off center		Positioned V		<b>-</b>		
	Heat Trea			Cut Too Short		Mislabe			Power Loss/	Surge	Other		
	Inspectio		Tube	Drawing	<u> </u>	Misread							
	Marks/Cl			Drill Holes		Off-set							
		Sequence		Finish		-	Calibration						
	IWave/Tw	vist in Tub	16	Fit/Function		I Out of 9	Saguence						

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## **Picklist Print**

Thursday, August 29, 2013 3:28:50 PM

Work Order ID:

106428

Parent Item:

D4148-041

Parent Item Name:

FWD X-TUBE LUG ASS'Y

**Start Date: 8/29/2013** 

Required Date: 8/30/2013

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

IPP Rev:C 10.10.29 as per revC

DD verf:EC

IPP REV:D 11.03.02 AS PER DWG REV.D DD VERF:EC

105862 105868

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4148-041 FWD X-TUBE LUG ASS"	ď	Manufactured	No				Each	14.0000		4			
				Location ST460		Loc Oty	<u>Lo</u>	c Code			13/09/0		NA 272 1

5 × 100 chas mx 12.0 - 0

DQA:	WORK ORDER NON-CONFORMANCE / UPDATE							TRAC					
QA Closed:			Date:			WORK ORDER NON-	-((	JINFUI	RIVIAINCE / U		Work Order u	odate only	AEROSPACE
Work Orde	or:					DISPOSITION		AGAINST DEPARTME				/PROCESS	
WOIR OIGE					Rework		Skid-tube Crosstube			7	Water Jet	Engineering	
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	10					Suspected Unapproved			Large Fab	Composite _		Supplier	
Root					Desci	ription of work order update	ı	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design	_												
Doc/Data													
Equip/Tooling	_												
Handling/Pre	_												*
Material	_												
Operator	_	l				•			*				
Offset/Setup	_												
Process						. ,							
Supplier	_					1.					•		
Training -	_												
Transport	$\dashv$												
Unapproved									55000				
l andi:							FAL	ULI CA	TEGORY				
Lanun	ng Geal	nding				<b>General</b> Bend		ا دمانم اد	1	Г	Outside Dim		7/5
	_		t Concer	stric	$\vdash$	BOM/Route		Grain	Program		<b></b>	<u> </u>	Pressure/Forced
	_	icks	Concer	ittic		Broken/Damage/Defect		Hardwa	uro.	-	Over/Under Part Incorre	<b>⊢</b>	Set-up Temperature/Cure
			k/Ripple,	/\// 240		Burrs		1	ire ion Incomplete/U	nauglified	_	. ⊢	╡ '
	Cut		v) ((ibbic)	/ wave		Contamination		1	-	· -	Part Lost/M Part Moved		Weld
		ıshing			<u> </u>	Countersink	-	1	ions Incomplete/Igned/off center	Officieal	Positioned V		Wrong Stock Pulled
ł		at Treat	•			Cut Too Short	$\vdash$	Mislabe		F	Power Loss/		Other
ŀ			Strip in	Tube		Drawing	$\vdash$	Misread		L			Other
		rks/Ch				Drill Holes		Off-set					,
	_		equence			Finish		ł	Calibration				
	_		st in Tub			Fit/Function		1	Sequence				
						<u> </u>	<u> </u>						

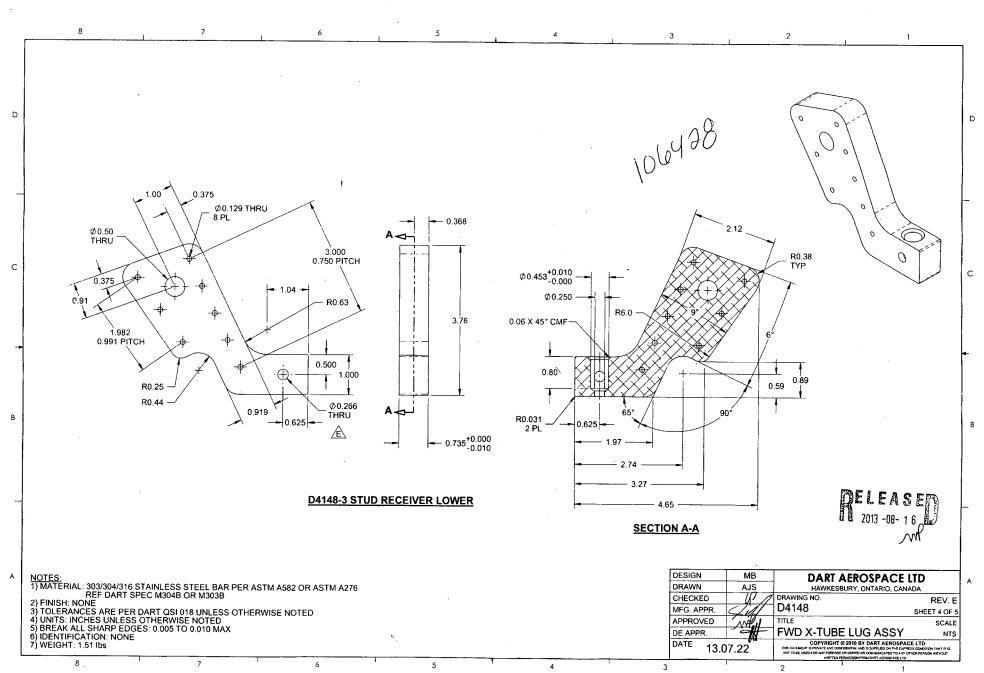
DART AEROSPACE LTD	Work Order:	106478
Description: /) 4/42-3 (FWD x-TuBE Luc Ass's	Part Number:	04149-041
Inspection Dwg: // 4/48 Rev:		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing	I	Actual	<u> </u>		Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
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0 500	+ 0.010	0.501	/		111	///
0,500	† 0,010 † 0,010	0,501	V		///	///
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Measured by: ///	Audited by:	DAS 27	Preliminary Approval:	
Date: /3/09/03	Date:	9-89 Q 64	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	



\_\_

DQA:	<u>-</u>	_ Date:			DART								
QA Closed:		Date:		WORK ORDER NO	WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only  Work Order update only								
W 10 1				DISPOSITION	DISPOSITION AGAINST				DEPARTMENT/PROCESS				
Work Orde	er:			— Parriada			Chief Andrea Comment				, <del></del>		
Part N	lo			Rework Scrap			Skid-tube Crosstube Machining Small Fal	$\vdash$	Dro	Water Jet	Engineering		
raitiv				Use-as-is	<b>—</b>		noforming Finishing	<u> </u>	l	d. Eng. Coor. re/Packaging	Quality Other		
NCR N	lo			Suspected Unapproved		HIEH	Large Fab Composite	~	Nec/3to	Supplier			
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Root				Description of work order upda	ite	Initial	Action		Sign &				
Cause	Date	Step	Qty	or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector		
Design									· · · · ·				
Doc/Data	:		;								·		
Equip/Tooling													
Handling/Pre	_	ĺ											
Material													
Operator													
Offset/Setup													
Process				` ` `									
Supplier				•									
Training	_			· · ·									
Transport													
Unapproved				A	•								
		······································			- FA	ULT CA	TEGORY						
Landir	ng Gear			General		1			1		<b>-</b>		
•	Bending			Bend	-	- i	Program	-	Outside Dim	<del> </del>	Pressure/Forced		
	Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave			BOM/Route		Grain		-	Over/Under	ļ	Set-up		
				Broken/Damage/Defect		Hardwa	•		Part Incorred	<b>⊢</b>	Temperature/Cure		
				Burrs	$\vdash$	1	ion Incomplete/Unqualified	-	Part Lost/Mi		Weld		
	Cuffs			Contamination	_	-	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled		
}	Crushing			Countersink	-	- 1	gned/off center		Positioned V		ا ا		
	Heat Tre		Tuba	Cut Too Short	-	Mislabe			Power Loss/Surge Other				
	Marks/C	on Strip in	equi	Drawing Drill Holes	<u> </u>	Misread					·		
		.natter Sequence		Finish	-	Off-set				<del></del>			
		sequence wist in Tub		Fit/Function	$\vdash$	4	Calibration						